

Work Order ID 140540

140540

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Thursday, January 07, 2016 1:25:52 PM

Item ID: D2761-108

Revision ID:

Item Name: Extrusion (HPK)

Start Date: 1/7/2016 Start Qty: 100.00

Required Date: 1/7/2016 Req'd Qty: 100.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: JAN 07 2016 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2761	Rev A1								

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 31027

0.00

a) Extrude as per Dwg D2761

b) Material: 6061-T6 (QQ-A-200/8)

c) No tooling ID mark

d) Extrusion is symmetric about center line

e) Caradon Indalex Die# MS-19021f) Order at 108" long

g) Material certification required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DAS
13
9-89

JAN 15 2016

108

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Work Order ID 140540***140540***

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Thursday, January 07, 2016 1:25:52 PM

Item ID: D2761-108 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Extrusion (HPK)
Start Date: 1/7/2016 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 1/7/2016 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure certification comply to Dwg D2761 Check hardness with Webster instrument								
130	Identify as per dwg & Stock Location: MAT051	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION: MAT051								

114X Sp 16-03-22

(114) 16-03-24 DAS 9 9-89

113 P.T.O.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Work Order ID 140540

140540

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Thursday, January 07, 2016 1:25:52 PM

Item ID: D2761-108 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Extrusion (HPK)
Start Date: 1/7/2016 Start Qty: 100.00 *100* Cust Item ID:
Required Date: 1/7/2016 Req'd Qty: 100.00 *100* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS APR 25 2016

MCS APR 25 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐ _____			

Picklist Print

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Thursday, January 07, 2016 1:25:56 PM

Work Order ID: 140540

140540

Parent Item: D2761-108

D2761-108

Parent Item Name: Extrusion (HPK)

Start Date: 1/7/2016

Required Date: 1/7/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: B01.05.03Re formatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2761-108P		Purchased	No			100	f	0.0000	1	100	114X		
D2761-108P									**	114X			
Extrusion													

Spille-03-22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



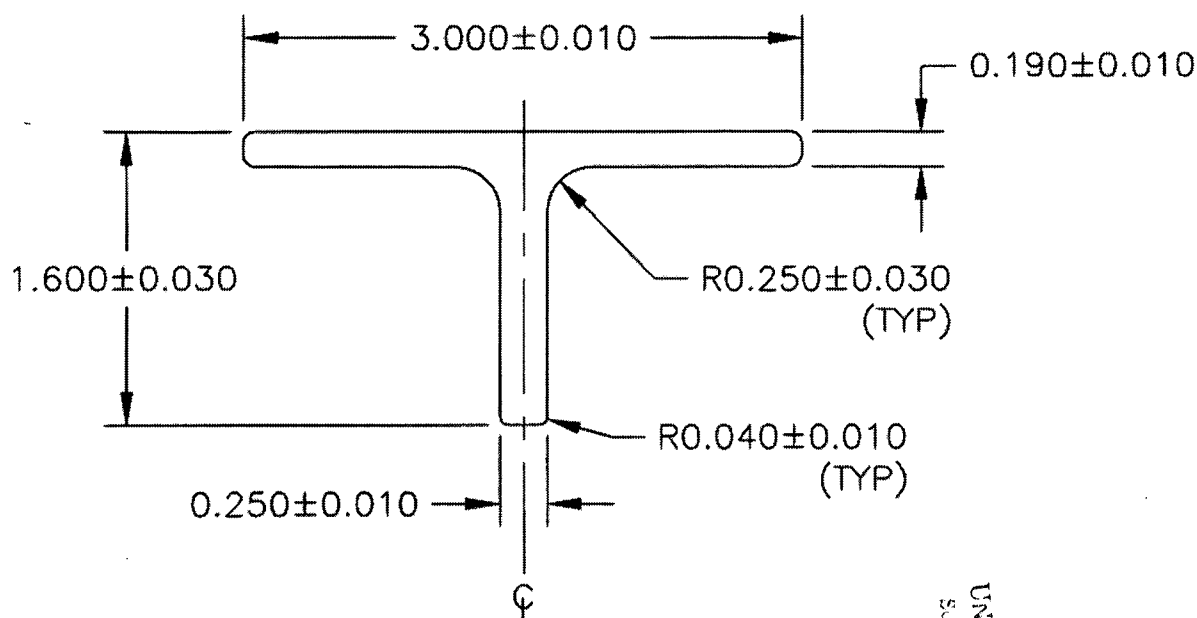
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>1108</i>	APPROVED <i>A</i>	DRAWING NO. D2761	REV. A SHEET 1 OF 1
DATE 98.03.16		TITLE EXTRUSION	SCALE 1:1
A	98.03.16	NEW ISSUE	
AI	01.04.17	ADD NOTES 4 & 5 + CP	

RELEASED
98104/03 KE

1. MATERIAL: 6061-T6 (QQ-A-200/8).
2. NO TOOLING ID MARK.
3. EXTRUSION IS SYMMETRIC ABOUT CL.
4. MANUFACTURED USING CARADON INDALEX DIE # MS-19021
5. PART NUMBER IS D2761-XXX WHERE XXX IS CUT LENGTH IN INCHES
EG. D2761-108 IS 108" LONG

SKN COPY
REQ. 10/11
ENG. 10/11
UNCONTROLLED COPY
SUB. 10/11
W. 10/11
140540 M05
16-01-07



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31027

Purchase Order Date 1/15/2016
PO Print Date 1/15/2016

Page Number 2 of 2

Order From :

VC-BON001

Ship To : DART AEROSPACE LTD

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-427-6550

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

3	D2761-108P	Extrusion	3/29/2016	108.00	31.25	\$3,375.00
			Yes	f		
			3/29/2016			

EXTRUDE AS PER DWG D2761 REV. A
B140540

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE
MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS

See 1144
SP 16-03-22

Line Total: \$3,375.00

4	71401-45	UREMENT QUALITY CLAUSES	3/29/2016	1.00	\$0.00	\$0.00
			No			
			3/29/2016			

Procurement Quality Clau:

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

Line Total: \$0.00

PO Total: \$14,745.16

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

Change Date: 1/15/2016



1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD

PICKERING ON L1W 3R8

PACKING LIST

ACCT# 46024

PACKING LIST DATE / DATE DU
03-21-16PACKING LIST NUMBER / N° DE
025233SALES ORDER NUMBER / N° DE COM
122086

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION		TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP DES VENTES						
PIC		RT104	042		R. BLAIS						
CUSTOMER ID / ID DU CLIENT	ORDER DATE / DE LA COM	CUSTOMER PO NUMBER / CLIENT PO Nombre		JOB / FICHER	FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP SERVICE CLIENTELE					
46024	01/15/16	PO31027 BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 025233		CARRIER / TRANSPORTEUR MCGILLION	G.ATTENBOROU	M2A					
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
003	1,104 LB			DAA-7-1	6061 T6		3	1,155	1,124 LB		
	501 KG			D2761-108P	108.0000 IN			524	510 KG		
	108 PC				Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			114 PC		✓
						861171 / 300508	1	66	57		6 PC
						861171 / 300541	1	604	593		60 PC
						861171 / 300542	1	485	474		48 PC

Sp16-03-22

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below

by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

Page 3

10	4,810	4,528	LB
	2,182	2,054	KG
		336	PC
TOTALS			

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
03/16/2016	5380789	122086	1
Cust PO	B/L No	Lot	Date
PO31027	025233	861171	03/21/16

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
003	DAA-7-1	9FT MILL 6061 T6	D2761-108P
Gross Weight	1,155 LBS		
Net Qty	1,124 LBS		114 PCS
Specification			3 PKGS
AMS-QQ-A-200/D & ASTM B221-08			Die Desc

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
295.9 / 42.9	269.0 / 39.0	12.3	N/A	93

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.69	0.19	0.23	0.05	0.89	0.06	0.15	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc



ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2761-108
DATE: 16-03-24

PO / BATCH NO.: P031027 / B140540

MATERIAL CERT REC'D: yes
QUANTITY RECEIVED: 114 pcs
QUANTITY INSPECTED: 114 pcs
QUANTITY REJECTED: 0

THICKNESS ORDERED: N/A
THICKNESS RECEIVED: N/A
SHEET SIZE ORDERED: N/A
SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	(Y)	N	
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT MATERIAL	(Y)	N	AMS-QQ A-200/B
CORRECT REF # TO LINK CERT	(Y)	N	P031027
CORRECT MATERIAL IDENTIFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u> <u>9</u> <u>9-09</u>	SIGNED OFF BY: _____		
DATE: <u>16-03-24</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRINATOR BEFORE GOING FURTHER



Supplier Non-Conformance Report

Reviewed		Printed on: Monday, May 02, 2016	
DQA:			
Date:			
Details			
Raised Date 4/25/2016	Status Open	Owner Downing, Eric M	Number NCR16-5736
Target Date 5/2/2016	Standard		Severity MAJOR
Process Employee finding		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Signature Aluminum Canada Inc.		Fault Category Material
Details during storage of material, employee notice groove .125"x.0.64" running length wise of D2761-108 extrusion. See attach picture. PO31027			
Keywords		Product D407-301\D2764	
Document		Root Cause Materials	
Closed By	Closed Date	Resolution	
Corrective Action			
Target Date 5/2/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			
Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	5/2/2016	
Contact Supplier and obtain corrective action		see attached emails.	
2	Downing, Eric M	4/29/2016	 40502
scrap length of faulty material as per instructed by supplier			

Verification & Review			
Target Date 5/2/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	